

Work Order ID 81756

Friday, March 16, 2012 3:37:32 PM

81756April 4th
Page 1

Item ID: D3914-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Long Basket Lid Assembly (350)
Start Date: 3/19/2012 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 4/6/2012 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: MF Date: 12-03-16 Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3914	B
D4020	A

100 Weld per dwg A/R S.S. rod Batch: 118366 0.00
Large Fab

100

Large Fab

Large Fab

Memo 0.00

1- assemble ribs , weld as per dwg D3914 using DT9607A

2- weld hinge (3) and Mounting brackets as per dwg D3914

Visual inspect before welding mesh

3- tack weld mesh on basket as per dwg D3914

Cut out mesh where label plate goes in center off basket lid as per dwg D4020-5. Make sure to place mesh correctly on lid, check with label plate before tacking mesh

PC 12.04.03 1x Ø

110 QC9- Inspect visual per QSI004- Fusion Welds 0.00

110

QC

Quality Control

Memo 0.00

12.04.04

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

***Mask label plate to size of label, use scotchbrite red pad to lightly sand area for label, apply label ***

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NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 81756

Parent Item: D3914-041

Parent Item Name: Long Basket Lid Assembly (350)

Start Date: 3/19/2012

Required Date: 4/6/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC
10.08.18 verified by:EC

IPP Rev:B as per dwg revB DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2581 Mounting Bracket		Manufactured	No			100	Each	23.0000	2				
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA005		23							
				69739		1							
				70766		2							
				77045		1							
				77523		19							
D3914-1 Rib		Manufactured	No			100	Each	0.0000	2				
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA		2							
				WA006		-2							
D3914-7 Rib		Manufactured	No			100	Each	12.0000	2				
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA006		12							
				80164		2							
				81208		10							
D4016-3 Hinge Half, Lid		Manufactured	No			100	Each	15.0000	3				
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA005		15							
				78495		15							
D4018-5 Rib		Manufactured	No			100	Each	36.0000	9				
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA005		36							
				78041		35							
				80597		1							

SAD 12-03-30

B81253

SAD 12-03-30

B81407

SAD 12-03-30

01389

SAD 12-03-30

B80776

9

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Picklist Print

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Work Order ID: 81756

Parent Item: D3914-041

Parent Item Name: Long Basket Lid Assembly (350)

Start Date: 3/19/2012

Required Date: 4/6/2012

Start Qty: 1.00

Required Qty: 1.00

D4020-5
Mesh (350 Basket Long, Lid)

Manufactured No

100 Each 5.0000

1

Location

Loc Qty

Loc Code

WA

5

78698

1

81180

4

~~80897~~

B81180

SAD 12-03-30
→ ①

D4021-3

Data Plate

Manufactured No

100 Each

2.0000

1

Location

Loc Qty

Loc Code

WA005

2

75460

2

80897

①

D4035-041

Lid Rib Assembly, Fwd (350 Basket)

Manufactured No

100 Each

2.0000

1

Location

Loc Qty

Loc Code

WA006

2

74642

2

B 81 701

①

D4035-043

Lid Rib Assembly, Aft (350 Basket)

Manufactured No

100 Each

6.0000

1

Location

Loc Qty

Loc Code

WA006

6

81201

6

B81201

①

D2728-3

Dart Logo label

Manufactured No

140 Each

0.0000

1

115050

1 1 B 12-4-4.

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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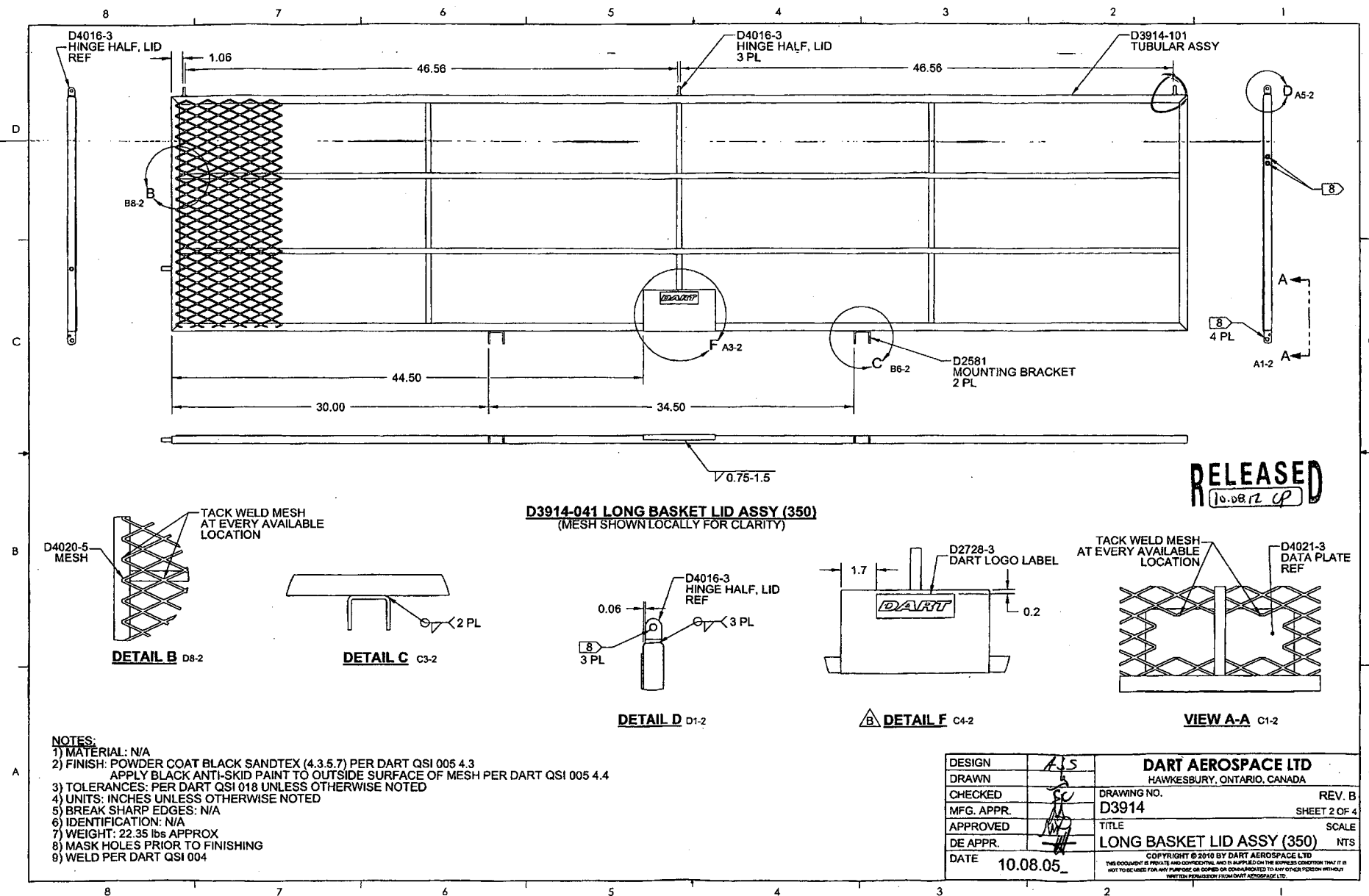
NOTE: Date & initial all entries

ITEM	QTY	P/N	DESCRIPTION
	X	D3914-041	LONG BASKET LID ASSY (350)
1	1	D3914-101	TUBULAR ASSY, LONG LID
2	2	D2581	MOUNTING BRACKET
3	1	D2728-3	DART LOGO LABEL
4	3	D4016-3	HINGE HALF, LID
6	1	D4020-5	LID MESH, 350 LONG BASKET
7	1	D4021-3	DATA PLATE

D3914-041 LONG BASKET LID ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

RELEASED
10.08.17 GP
E2N 10-596

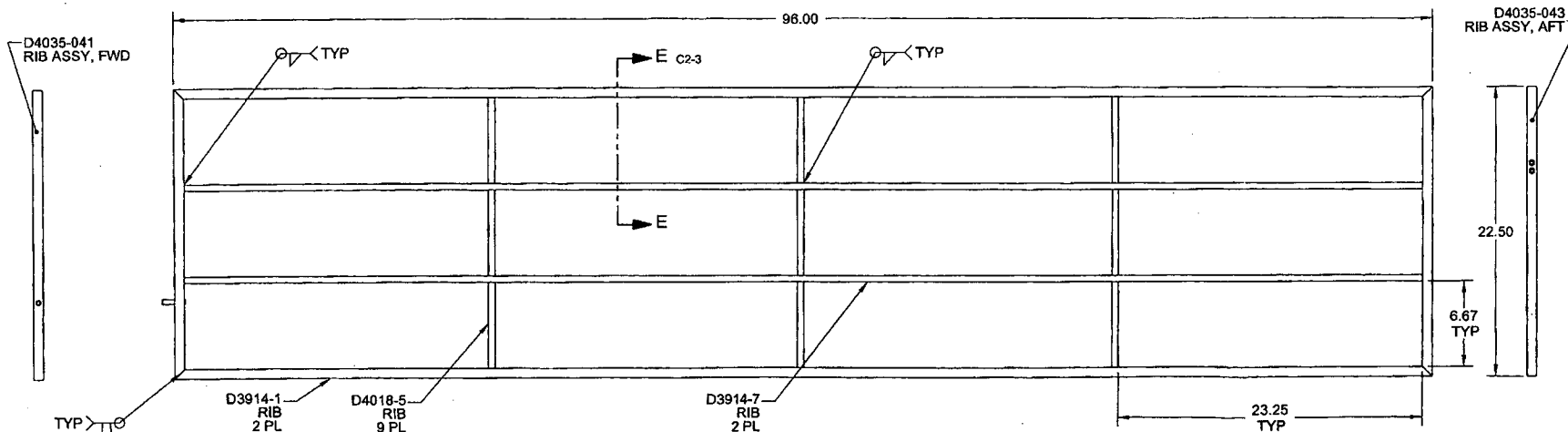
B	REMOVED D4086-210, UPDATED DETAIL F ACCORDINGLY (A3-2). REASON: NOW INSTALLED BY OPERATORS PER D350-607-2 REV. C AND D350-607-3 REV. A.	MB	10.08.05
A	NEW ISSUE	JPH	10.03.16
REV.	DESCRIPTION	BY	DATE
DESIGN	AS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC	DRAWING NO.	REV. B
CHECKED	SC	D3914	SHEET 1 OF 4
MFG. APPR.	AS	TITLE	SCALE
APPROVED	AS	LONG BASKET LID ASSY (350)	NTS
DE APPR.	AS	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY FORM OR BY ANY MEANS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	10.08.05		



ITEM	QTY -101	P/N	DESCRIPTION
	X	D3914-101	TUBULAR ASSY, LONG LID (350)
1	2	D3914-1	RIB
2	2	D3914-7	RIB
3	9	D4018-5	RIB
4	1	D4035-041	BASKET LID RIB ASSY, FWD
5	1	D4035-043	BASKET LID RIB ASSY, AFT



SECTION E-E C5-3



8 D3914-101 TUBULAR ASSY, LONG LID

RELEASED
10.08.12

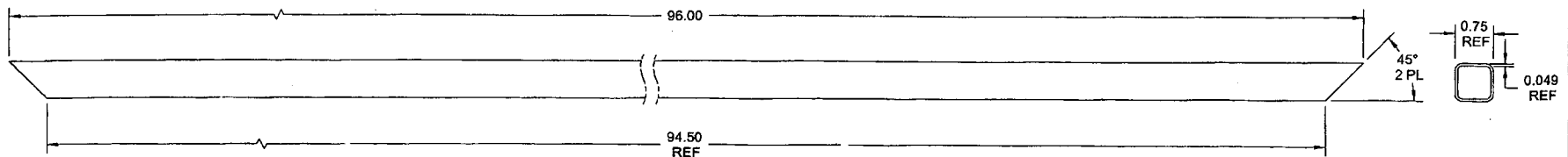
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 14.10 lbs
- 8) TOLERANCE FOR XX.XX DIMENSIONS ± 0.06 FOR D4018-101
- 9) WELD PER DART QSI 004

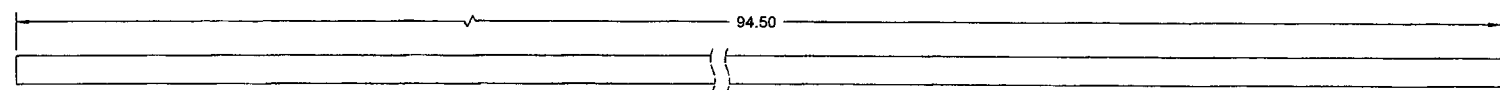
DESIGN	ALS	DART AEROSPACE LTD	
DRAWN	ALS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RC	DRAWING NO.	REV. B
MFG. APPR.	WJ	D3914	SHEET 3 OF 4
APPROVED	WJ	TITLE	SCALE
DE APPR.	WJ	LONG BASKET LID ASSY (350)	
DATE	10.08.05	NTS	
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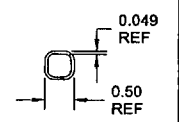
D



D3914-1 RIB



D3914-7 RIB



NOTES:

1) MATERIAL -1: AISI 304/316 SEAMLESS STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL
REF DART SPEC. M304TS0.750W.049

-7: AISI 304/316 SEAMLESS STAINLESS STEEL SQUARE TUBE, 0.50 X 0.50 X 0.049 WALL
REF DART SPEC. M304TS0.500W.049

- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: SEE ASSEMBLED WEIGHTS

RELEASED
10.08.12 LP

DESIGN	ALS	DART AEROSPACE LTD	
DRAWN	SC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	SC	DRAWING NO. D3914	REV. B
MFG. APPR.	SC	SHEET 4 OF 4	
APPROVED	SC	TITLE	SCALE
DE APPR.	SC	LONG BASKET LID ASSY (350)	NTS
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8 7 6 5 4 3 2 1

A